

# Work Order ID 122221

July-11-14 9:15:02 AM

\*122221\*

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*ASD*

*D3578-041*  
*B122221*

Item ID: D3578-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Doubler

Start Date: 7/11/14

Start Qty: 40.00

\*40\*

Cust Item ID:

Required Date: 7/11/14

Req'd Qty: 40.00

\*40\*

Customer:

Reference:

Approvals:

Process Plan: *MLJ*

Date: *1407-11*

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3578	Rev A

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3578 (Run prog. D3578-1)

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

*46* mm *14/07/14*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

*46* mm *14/07/14*

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

*685*  
*13*  
*105*  
*14/7/14*

*46*

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Item ID: D3578-041

Accept

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Revision ID:

Stop \*NS2\*

Item Name: Doubler

Start Date: 7/11/14

Start Qty: 40.00

\*40\*

Cust Item ID:

Required Date: 7/11/14

Req'd Qty: 40.00

\*40\*

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

\*130\*

Small Fab

Small Fab

Memo

0.00

0.00

1-Open rivet holes to 0.098" and C'sink as per dwg D3578

DAS

27

9-89

140

\*140\*

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Quality Control

150

\*150\*

HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

Hand Finishing

DAS  
36  
9-89

46x

14/07/15

M/H/15

46

con

46

7/15 14-7-15

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Item ID: D3578-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Doubler  
 Start Date: 7/11/14 Start Qty: 40.00 \*40\* Cust Item ID:  
 Required Date: 7/11/14 Req'd Qty: 40.00 \*40\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00  0.00				46x			14/02/15 DAS 3fi 9-89
170 *170* Small Fab Small Fab	Small Fab  Memo 1-Assemble as per dwg D3578	0.00  0.00				46x			14/07/15 DAS 3fi 9-89
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				46			4/7/16 DAS 27 9-89

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Item ID: D3578-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Doubler  
 Start Date: 7/11/14 Start Qty: 40.00 \*40\* Cust Item ID:  
 Required Date: 7/11/14 Req'd Qty: 40.00 \*40\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>8T050</u>	0.00							
*190*									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
*200*									
QC	Memo	0.00							
Quality Control									

46x 14-7-16 DAB 28 9-89

MLJ 14-07-17

14-7-16

# Picklist Print

July-11-14 9:15:05 AM

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Work Order ID: 122221

\*122221\*

Parent Item: D3578-041

\*D3578-041\*

Parent Item Name: Doubler

Start Date: 7/11/14

Required Date: 7/11/14

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: A07.04.11New issueEC  
IPP RevB 10.10.21 remove D3569-1 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD3-3 *MS20426AD3-3* RIVET		Purchased	No			110	Each	5,099.000	2	80		4/07/15	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST315				5099					
				123352				344					
				M128754				4755		92			
M6061T6S.080 *M6061T6S 080* 6061-T6 .080 Sheet		Purchased	No			170	sf	576.3760	0.007	1		mm 14/07/14	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT021				325.51					
				m126309				130.52					
				m126350				13.34					
				m128903				181.65		0.4			
				TPI				250.866					
				m129439				250.866					
MS21075L3 *MS21075L3* Nut Plate	MS21075L3N	Purchased	No			170	Each	8.0000	1	40		14/07/15	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST303				8					
				116398				8					

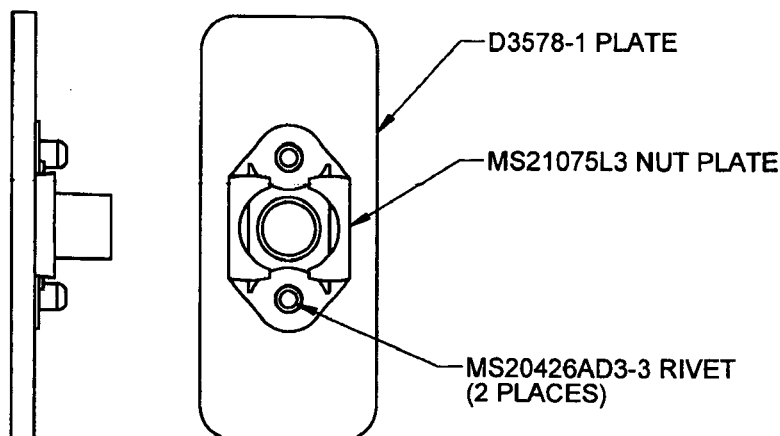
M128429 (16x)

M128257 (30x)





DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>HA</i>	DRAWING NO. <b>D3578</b>	REV. A SHEET 1 OF 1
DATE <b>07.01.12</b>		TITLE <b>DOUBLER</b> SCALE 3:2	
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE	



**RELEASED**  
07.04.02 #

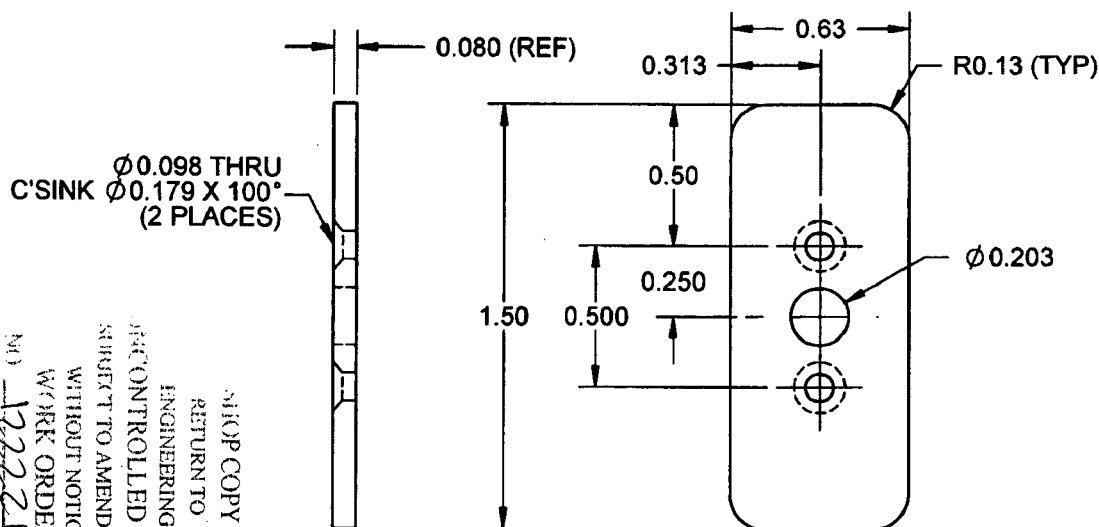
**D3578-041 PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

**D3578-041 DOUBLER**

**D3578-041 NOTES:**

- 1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER



**D3578-1 PLATE**

**D3578-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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